

# इंटरनेट

# मानक

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Mazdoor Kisan Shakti Sangathan

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IS 4299 (1982): Jig Feet [PGD 2: Machine Tool Elements and Holding Devices]



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“Knowledge is such a treasure which cannot be stolen”



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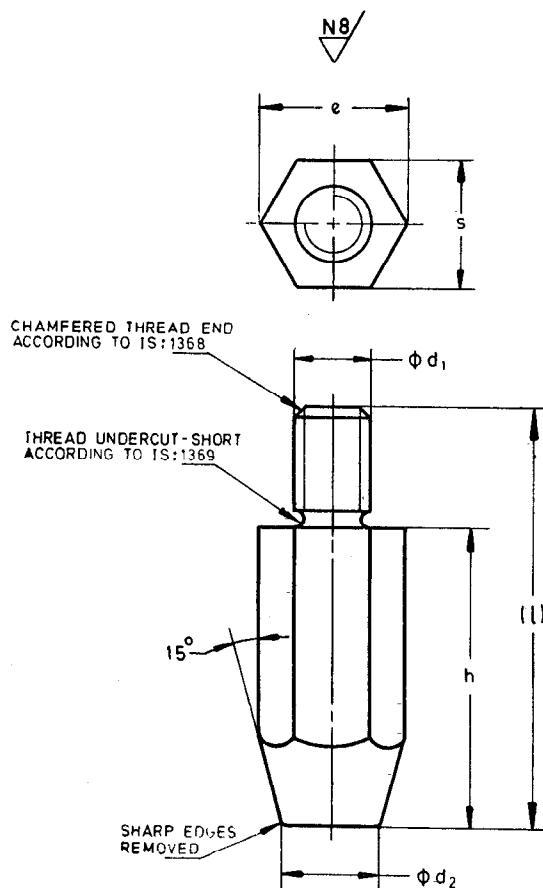


*Indian Standard*  
**SPECIFICATION FOR  
JIG FEET**

(First Revision)

**1. Scope** — Covers dimensions and material requirements for jig feet.

**2. Dimensions**



All dimensions in millimetres.

$h$	$d_1$ $6_s$	$l$	$d_2$	$e$	$s$
10	M6	21	8	11.5	10
20		31	6		
15	M8	28	10	15.0	13
30		43	9		
20	M10	36	13	19.6	17
40		56			
25	M12	45	15	21.9	19
50		70			

**Note** — Dimensional deviations for untoleranced dimensions: Medium class according to IS : 2102(Part I)-1980 'General tolerances for dimensions and form and position: Part I General tolerances for linear and angular dimensions (second revision)'.

Adopted 19 February 1982

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ISI

**IS : 4299 - 1982**

**3. Material** — Steel having a tensile strength of 370 MPa, *Min.*

**3.1** The contact face  $d_2$ , if agreed to between the manufacturers and the users, shall be hardened to 550 HV, *Min.*

**4. Designation** — A jig foot having  $h = 15$  mm and  $d_1 = M8$  shall be designated as:

Jig Foot 15 × M8 IS : 4299

**5. Finish** — The jig feet shall be free from cracks, burrs, pits and other defects.

**6. Preservation and Packing**

**6.1** A suitable anti-corrosive surface treatment shall be given to jig feet.

**6.2** The jig feet shall be packed in suitable cartons so as to prevent damage during transit.

**7. Marking** — The carton containing jig feet shall be marked with designation and the manufacturer's name or trade-mark.

**7.1 ISI Certification Marking** — Details available with the Indian Standards Institution.

**EXPLANATORY NOTE**

This standard was first published in 1967 and was based on DIN 6320 : 1935. The present revision has been taken up in order to incorporate the latest manufacturing practices. In this revision, the following changes have been incorporated:

- a) Across flat dimension 's' is altered to suit standard hexagonal bar stock.
- b) An undercut is provided after the thread for proper fit. This would avoid special countersunk on corresponding threaded hole.
- c) A 15° taper has been provided for the point on the foot to facilitate easy manufacture.

While preparing this standard, assistance has been derived from DIN 6320-1971 'Feet with threaded shank for jigs and fixtures', issued by Deutsches Institut für Normung (DIN).